

Date: Thursday, 7/3/2008 3:31:35 PM
 User: Kim Johnston

Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN DOOR ROLLER KIT, RH
Job Number : 40224	
Estimate Number : 10289	
P.O. Number :	Part Number : D412698012
This Issue : 7/3/2008 S.O. No. :	Drawing Number : IIN D412-698 REVD
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 39917	Material :
Written By :	Due Date : 7/30/2008 Qty: 2/10 Um: Each
Checked & Approved By : <u>08.07.04</u>	
Comment : Est Rev: 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS	
Est Rev: D 08-01-28 change to rev D ECN 1104 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Photocopy bluefile and create labels per PPP D412-698-012 CHG003

S 08/08/08

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	D3121141	Bracket Assembly
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
3 D3121-141	Bracket Assembly	39921 x6

AS 08/08/08 (x2)

4.0	D3121144	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
1 D3121-144	Bracket Assembly	39923

AS 08/08/08 (x2)

5.0	D3137043	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
1 D3137-043	Bracket Assembly	29725

AS 08/08/08 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 40224

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Seq. #:

Machine Or Operation:

Description :

6.0

D3183044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3183-044

Bracket Assembly

40251 x 2

JS 08/08/08 (2)

7.0

D31991

Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

9 D3199-1

Bracket

B340031 x 9 ~~B39874 x 9~~
B39843 x 9

JS 08/08/08 (2)

8.0

D32021

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3202-1

Cover

B38445 x 2 ~~B46553 x 2~~

Fix in ramp
had to do a split.

JS 08/08/08 (2)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/08/08 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-012

Location:

Rev B

JS 08/08/08 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 08/08/11

Job Completion



MF 08-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40224

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Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

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Comment: DOCUMENT CONTROL JUD 08.7.08
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2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
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3.0 D3121141 Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Pick: Packing Kit
 Qty Part Number Description Batch
 3 D3121-141 Bracket Assembly _____

REFERENCE ONLY

4.0 D3121144 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick: Packing Kit
 Qty Part Number Description Batch
 1 D3121-144 Bracket Assembly _____

5.0 D3137043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick: Packing Kit
 Qty Part Number Description Batch
 1 D3137-043 Bracket Assembly _____